Work Order ID 97242

February-14-13 1:17:51 PM

97242

Item ID: D3954-7 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Ratchet Lug

Start Date: 2/08/13 **Start Qty:** 4.00 *4*

Required Date: 2/25/13 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 13-02-15 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3954	Revision Nbr: D								
100		0.00							
100									
Mill Conv	**Memo**	0.00	MJP 13/04/10			4			
Conventional Milling Machine	mill to size		AK						
110		0.00							
110									
Waterjet	**Memo**	0.00				3	1		JM 13-4-15
FLOW CNC Waterjet	1-Cut as per Dwg D3954 Dwg Rev: D Prog Rev: D 2-Deburr if necessary								

PTO →

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [illegible] Date: 13/05/22

QA Closed: [illegible] Date: 13/5/9

Work Order: 97242

Part No. D3954-7

NCR No. 13-2560

DISPOSITION

Rework	
Scrap	X
Use-as-is	
Work Order Update	

AGAINST DEPARTMENT/PROCESS → Programming

Skid-tube		Crosstube		Water Jet	X
Machining		Small Fab		Prod. Eng. Coor.	
Thermoforming		Finishing		Rec/Store/Packaging	
Large Fab		Composite		Supplier	

Engineering			
Quality			
Other	X		

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	X	13-4-15	100	1x	Reprogrammed to eliminate gauge from part; Hole came out too large (0.800). Hole path was on wrong side. Reprogram path to inside of hole to give correct dimension.	DAS 16 8-8 Q72443 13/05/08	Scrap + destroy. No - Recut. 19987	Jm 13-4-15 13-05-16	23/05/24	DAS 16 9-8 Q72443 13/05/08
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

	Bending
	Centre Not Concentric to O/S
	Cracks
	Crushed/Crimped
	Cuffs
	Heat Treat
	Inspection Strip in Tube
	Ripples in Bend
	Torque Waves in Extrusion
	Turning Sequence
	Wave/Twist in Tube

General

	Bend
	BOM/Route
	Broken/Damaged
	Burrs
	Contamination
	Countersink
	Cut Too Short
	Drill Holes
	Drawing
	Finish
X	Folio (wrong path)

	Grain
	Hardware
	Inspection Incomplete
	Instructions Incomplete/Unclear
	Maintenance
	Mislabeled
	Misread
	Offset
	Out of Calibration
	Out of Sequence
X	Outside Dimensions

	Ovalized
	Over/Under tolerance
	Part Incorrect
	Part Lost/Missing
	Part Moved
	Positioned Wrong
	Power Loss/Surge

	Pressure/Forced
	Temperature/Cure
	Weld
	Wrong Stock Pulled
	Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97242

97242

February-14-13 1:17:51 PM

Item ID: D3954-7 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Ratchet Lug

Start Date: 2/08/13 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 2/25/13 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						3	1		JM13-4-15
QC	**Memo**	0.00							
Quality Control									
125		0.00							
125						3	1		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Open hole using 0.748" reamer and mill as per Dwg D3954								
		MJP 13/04/23 FK							
127	QC2- Inspect parts off machine FAI/FAIB	0.00							
127		MJP 13/04/23 FK				3	1		
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

_____

_____

_____

Work Order ID 97242 *97242*

February-14-13 1:17:51 PM

Item ID: D3954-7 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Ratchet Lug

Start Date: 2/08/13 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 2/25/13 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____ **Run Start** *NR1*

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	ok 13/04/24			3	1		
140 *140* SprayPaint Spray Painting 13.05.07 M116329	~~Spray Painting per QSI005 4.2~~ **Memo** ~~SPRAY PAINT YELLOW AS PER NOTE 2 ON DWG D3954 (PAGE 3)~~ powder coat yellow safety per QSI005 temp: 400°F start time: 7:40 finish time: 8:10	0.00 0.00				3X	Ø		M.J. 13/05/07
150 *150* QC Quality Control	~~QC14- Inspect Spray Paint~~ Qc 3 **Memo**	0.00 0.00 DAS 27 BS7			3				

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 97242

February-14-13 1:17:51 PM

97242

Item ID: D3954-7 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Ratchet Lug

Start Date: 2/08/13 **Start Qty:** 4.00 *4*
Required Date: 2/25/13 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: [illegible]	0.00				3x			SP
160									B-5-7
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170						13/5/8			
QC	**Memo**	0.00							
Quality Control									

B-05-7

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
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- ☐ Heat Treat
- ☐ Inspection Strip in Tube
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- ☐ Turning Sequence
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General

- ☐ Bend
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- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

February-14-13 10:54:33 AM

Work Order ID: 97242

Parent Item: D3954-7 **Start Date:** 2/08/13 **Required Date:** 2/25/13

Parent Item Name: Ratchet Lug **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X2.000 303 BAR 1" X 2"		Purchased	No			100	f	15.9567	**0.5**	**2.1052632**			

Location	Loc Qty	Loc Code
MAT049	15.9567	
121921	3.9567	
123701	12	

P 2,125

MJP 13/04/10

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

_____

_____

_____

DART AEROSPACE LTD	Work Order:	97242
Description: Ratchet Lug	Part Number:	D3954-7
Inspection Dwg: D3954 **Rev:** D		Page 1 of 1

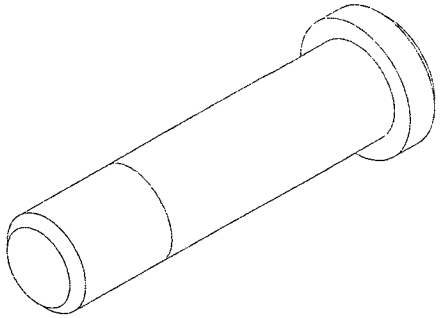
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.876"	–		V	JM
6.00	+/-0.030	5.975"	–		V	
1.50	+/-0.030	1.503"	–		V	
5.250	+/-0.010	5.248"	–		V	
3.25	+/-0.030	3.25"	–		V	
2.63	+/-0.030	2.63"	–		V	
1.00	+/-0.030	1.002"	–		V	
0.500	+0.025/-0.000	0.504"	–		V	
0.25	+/-0.030	0.25"	–		V	
Manual Mill → Ø0.750	+0.007/-0.001	0,753	✓		~~MJP-04~~	vern
R. 0,25	± 0,030	0,250	✓		✓	Radius Gages
0,13 x 45°	± 0,030/0,5°	0,120/45°	✓		MJP-04	vern
~~[illegible]~~	~~[illegible]~~	~~[illegible]~~	~~[illegible]~~	~~[illegible]~~	~~[illegible]~~	~~[illegible]~~
Ø 0,625	+0.008 −0.001	0,628	✓		MJP-04	vern
0,750	± 0,010	0,759	✓		MJP-04	vern
0,438	± 0,010	0,435	✓		MJP-04	vern

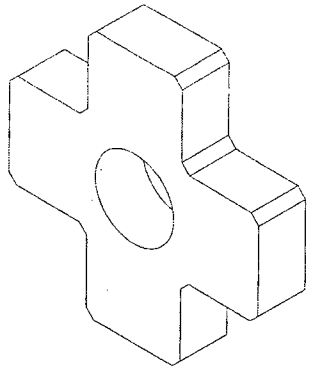
F.A. MJP 13/04/23

Measured by:	JM	Audited by:		Preliminary Approval:	
Date:	13-4-15	Date:	13/04/24	Date:	

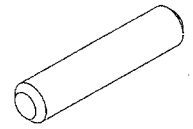
Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	
C	12.03.08	Dimensions updated per Dwg Rev C	KJ	



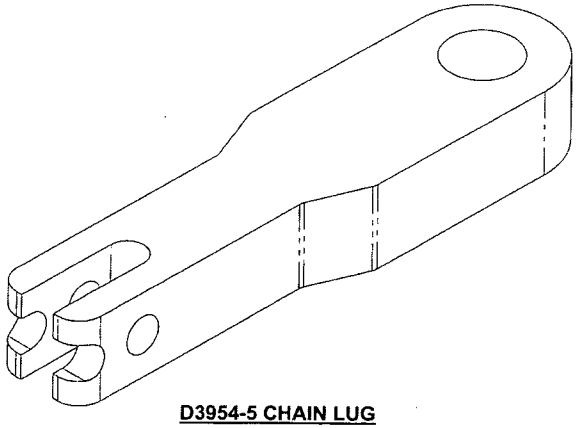
D3954-1 GWT PIN



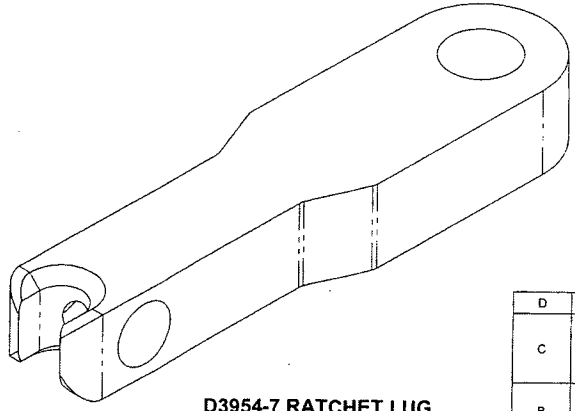
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

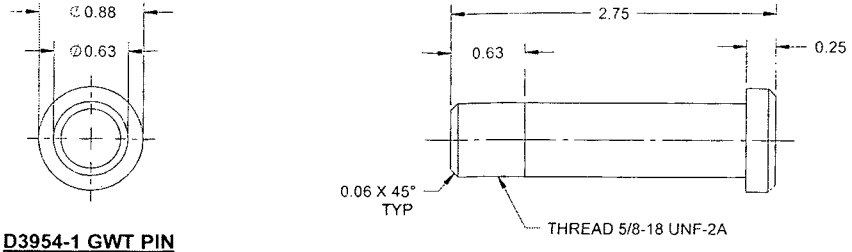
SUPPLY COPY
ENGINEERING
UNCONTROLLED COPY
9724/2MCS
13-02-15

RELEASED
2012 -10- 01

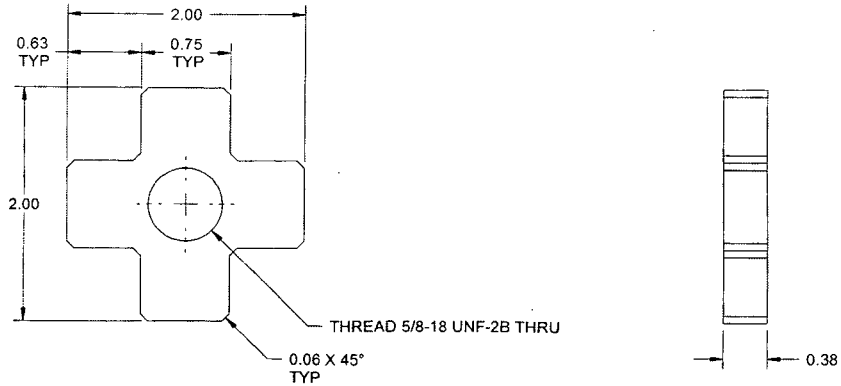
REV.	DESCRIPTION	BY	DATE
D	ZN A6-2, A6-3. REVISED NOTE 2 TO ADD POWDER COAT.	DC	12.08.10
C	MATERIAL UPDATE FOR D3954-1/-3: NOW STAINLESS STEEL ONLY (A8-2); FINISH CHANGED TO "NONE" FOR D3954-1/-3 (A8-2); TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3); D3954-9 NOW A PURCHASED PART (A2/A6-3). REASON: PAR11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26

DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED		DRAWING NO. D3954	REV. D
MFG. APPR.			SHEET 1 OF 3
APPROVED		TITLE MISC MACHINED PARTS GWT KIT	SCALE NTS
DE APPR.	N/A		
DATE	12.08.10		

97242



D3954-1 GWT PIN



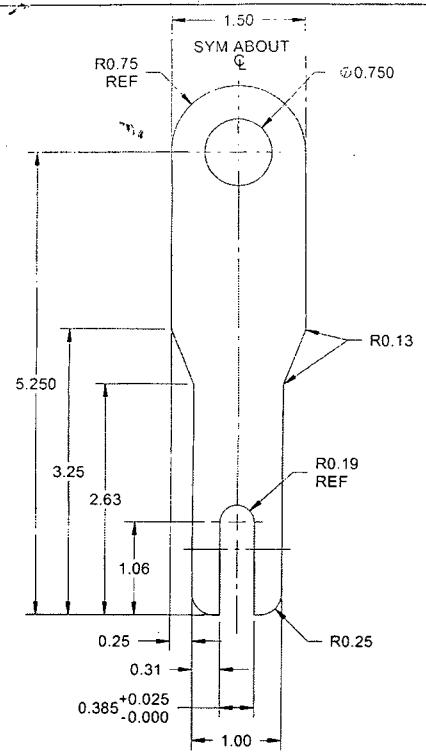
D3954-3 GWT KNOB

RELEASED
2012 -10- 01

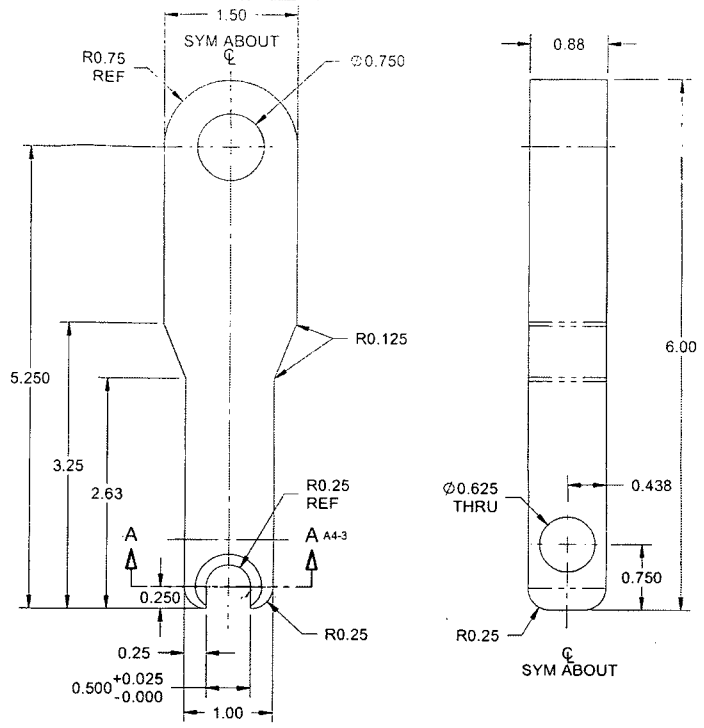
NOTES:
1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3 (D)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

DESIGN	AJS/DSTOW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO. CANADA
DRAWN	DC	
CHECKED	[illegible]	DRAWING NO. D3954 REV. D
MFG. APPR.	[illegible]	SHEET 2 OF 3
APPROVED	[illegible]	TITLE MISC MACHINED PARTS GWT KIT SCALE NTS
DE APPR.	N/A	
DATE	12.08.10	

97242



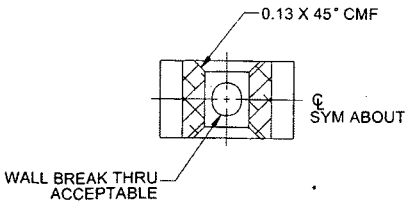
D3954-5 CHAIN LUG



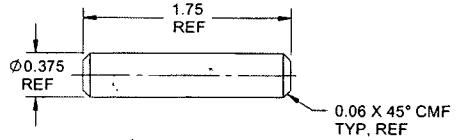
D3954-7 RATCHET LUG

RELEASED
2012-10-01

NOTES:
1) MATERIAL:
-5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B
-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)
ALTERNATE MATERIAL:
-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)
2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3 (D)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs REF



SECTION A-A C3-3



D3954-9 GWT CHAIN PIN

DESIGN	AJS/DSTOW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED	AB	DRAWING NO. D3954 REV. D
MFG. APPR.	JV	SHEET 3 OF 3
APPROVED	MD	TITLE MISC MACHINED PARTS GWT KIT SCALE NTS
DE APPR.	N/A	
DATE	12.08.10	